

Date: Thursday, 19/03/2009 11:06:10 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 46594	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 45668	Material :
Written By :	Due Date : 10/04/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUL 09-03-19</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6102013

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: B46414

J.F. 09/04/05 (8)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 46594 Double check by: JP

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

J.F. 09/04/06 (8)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/04/06 (8)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JP 09/04/06 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:06:11 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 46594

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(x8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMP/BR

09/04/06

6.0

POWDER COATING

POWDER COATING



m110939

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:55
OVEN TEMPERATURE: 320°
FINISH TIME: 2:25

FL 09/04/08

(8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT

BR 09-04-8

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(8)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 1129

9/4/9

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	W0594
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		0.486"	0.486"	0.486"	0.486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.146"	3.146"	3.146"	3.146"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		0.377"	0.377"	0.377"	0.377"		
F	0.490	0.510		0.492"	0.500"	0.502"	0.503"		
H									
I	R1.575	R1.595		R1.586"	R1.588"	R1.588"	R1.588"		
J	0.240	0.260		0.252"	0.249"	0.251"	0.251"		
K	0.490	0.510		0.502"	0.503"	0.502"	0.502"		
L	3.590	3.650		3.632"	3.632"	3.632"	3.632"		
M	0.315	0.322		0.320"	0.320"	0.320"	0.320"		
N	0.256	0.262		0.257"	0.257"	0.257"	0.257"		
O	6.500	6.520		6.512"	6.512"	6.512"	6.512"		
P	5.990	6.010		6.000"	6.000"	6.000"	6.000"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.505"	2.505"	2.505"	2.505"		
S	2.245	2.255		2.248"	2.248"	2.248"	2.248"		
T	1.120	1.130		1.125"	1.125"	1.125"	1.125"		
U	0.540	0.560		0.550"	0.550"	0.548"	0.550"		
V	0.793	0.803		0.794"	0.794"	0.794"	0.794"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		0.060"	0.060"	0.060"	0.060"		
Y	0.100	0.120		0.110"	0.110"	0.110"	0.110"		
AA	R1.125	R1.145		R1.132"	R1.134"	R1.134"	R1.134"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		0.635"	0.635"	0.635"	0.635"		
AD	0.240	0.260		0.260"	0.257"	0.257"	0.257"		
AE	1.810	1.830		1.823"	1.823"	1.823"	1.823"		
AF	0.240	0.260		0.253"	0.255"	0.254"	0.255"		
AG	0.140	0.160		0.153"	0.152"	0.151"	0.152"		
AH	0.140	0.160		0.160"	0.160"	0.160"	0.154"		
AI	0.140	0.160		0.160"	0.160"	0.160"	0.160"		
Accept/Reject									

Measured by:	J.F.
Date:	09/04/05

Audited by:	SS
Date:	09/04/06

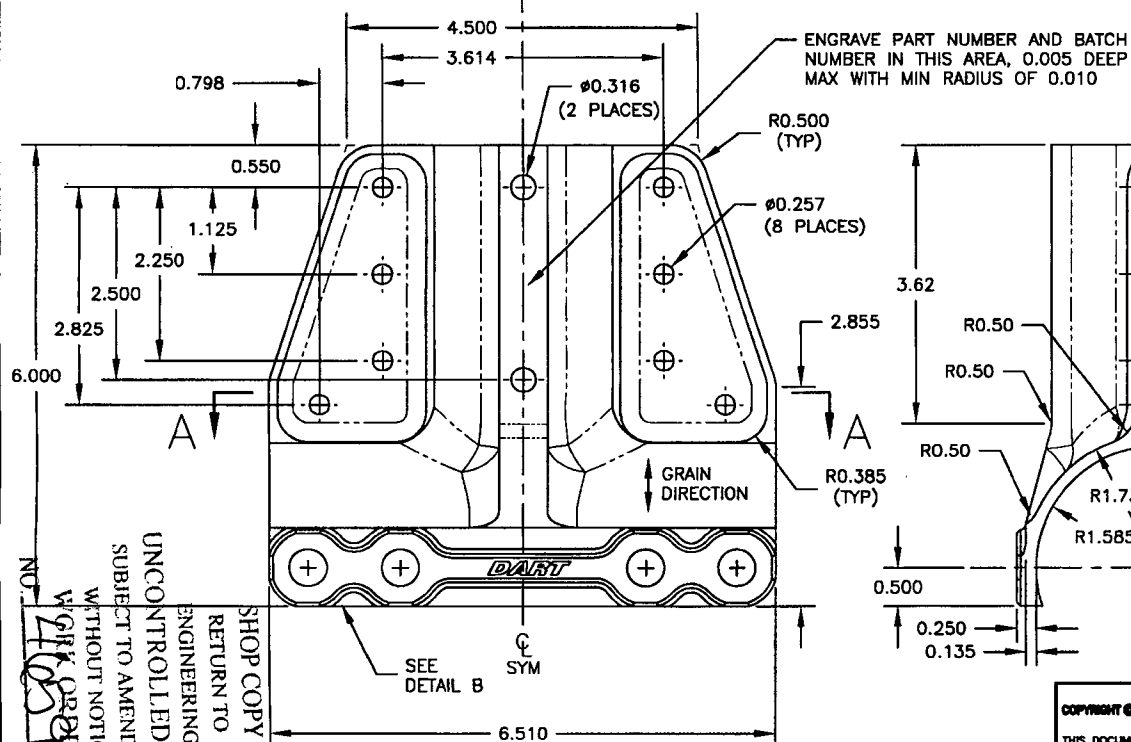
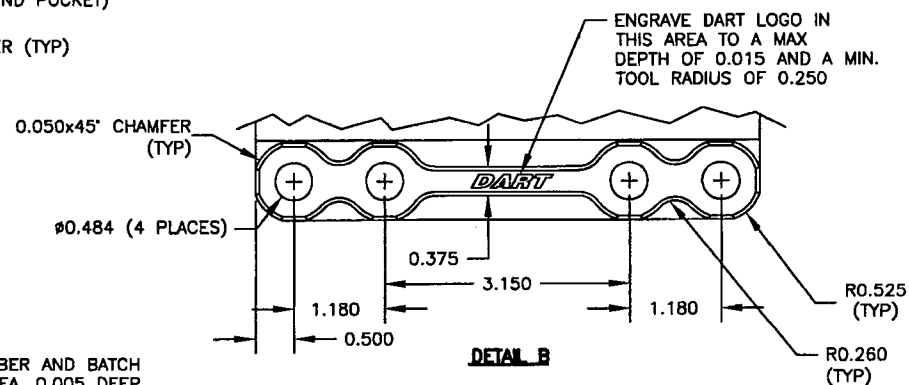
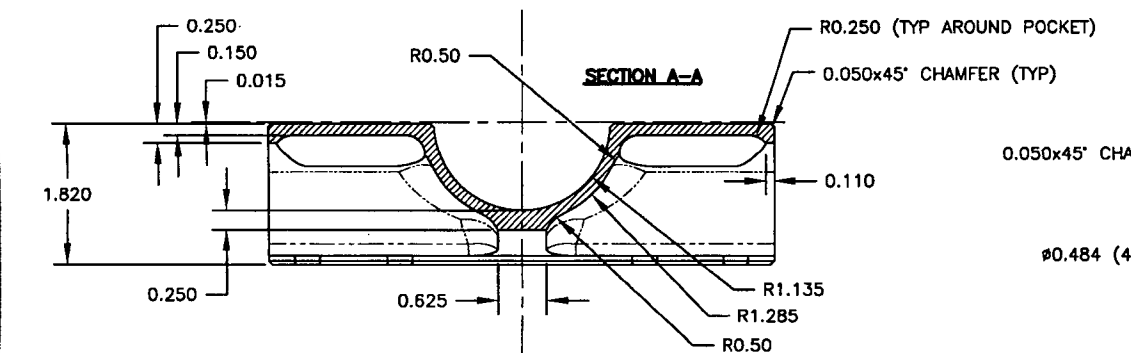
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 46594
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500		Rev: C
		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		Ø.486"	Ø.486"	Ø.486"	Ø.486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.146"	3.146"	3.146"	3.146"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		.377"	.377"	.377"	.377"		
F	0.490	0.510		.502"	.501"	.501"	.501"		
H									
I	R1.575	R1.595		R1.590"	R1.589"	R1.590"	R1.591"		
J	0.240	0.260		.250"	.250"	.250"	.249"		
K	0.490	0.510		.501"	.503"	.502"	.502"		
L	3.590	3.650		3.632"	3.632"	3.632"	3.632"		
M	0.315	0.322		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
N	0.256	0.262		Ø.257"	Ø.257"	Ø.257"	Ø.257"		
O	6.500	6.520		6.512"	6.512"	6.512"	6.512"		
P	5.990	6.010		6.000"	6.000"	6.000"	6.000"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.505"	2.505"	2.505"	2.505"		
S	2.245	2.255		2.248"	2.248"	2.248"	2.248"		
T	1.120	1.130		1.125"	1.125"	1.125"	1.125"		
U	0.540	0.560		.550"	.550"	.548"	.550"		
V	0.793	0.803		.794"	.796"	.797"	.794"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.060"	.060"	.060"	.060"		
Y	0.100	0.120		.110"	.110"	.110"	.110"		
AA	R1.125	R1.145		R1.135"	R1.134"	R1.135"	R1.136"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.635"	.635"	.635"	.635"		
AD	0.240	0.260		.258"	.258"	.257"	.254"		
AE	1.810	1.830		1.823"	1.823"	1.823"	1.823"		
AF	0.240	0.260		.256"	.255"	.256"	.255"		
AG	0.140	0.160		.152"	.151"	.152"	.151"		
AH	0.140	0.160		.160"	.160"	.160"	.153"		
AI	0.140	0.160		.160"	.160"	.160"	.160"		
Accept/Reject									

Measured by: J.F.	Audited by: [Signature]
Date: 09/04/05	Date: 09/04/06

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	9P	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DART AEROSPACE LTD.		REVISIONS
		REV. C
		SHEET 1 OF 1
		SCALE 2:3

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WGT ORDER
NO. 400974
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY